

Date: Monday, 3/19/2007 8:13:27 AM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : EYEBALL ADAPTER
Job Number : 31260	
Estimate Number : 12244	
P.O. Number : N/A	Part Number : D3480043
This Issue : 3/19/2007 S.O. No. : N/A	Drawing Number : D3480 REV.B
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : SMALL /MED FAB	Drawing Revision : B
Previous Run : 28530	Material : N/A
Written By : <u>JA</u>	Due Date : 3/23/2007 Qty: 4 Um: Each
Checked & Approved By : <u>JA 07.03.19</u>	
Comment : est rev. A 06.02.07 new issue EC	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D34801	Flange
-----	--------	--------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part number	Description	Batch
X 1	D3480-1	Flange	B31280-

2.0	NAS1031C3W	Nutplate
-----	------------	----------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty	Part number	Description	Batch
4	NAS1031C3W	Nutplate	m101144-

mf 07-03-21

3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1

Spot weld as per dwg D3480

mf 07-03-21

4.0	QC11	VISUAL INSPECTION OF SPOT WELDING
-----	------	-----------------------------------



Comment: VISUAL INSPECTION OF SPOT WELDING

SB 07/03/22

5.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

SB 07/03/22

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: LR Date: 27/03/26  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Monday, 3/19/2007 8:13:28 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: EYEBALL ADAPTER

Job Number: 31260

Part Number: D3480043

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with a permanent fine point marker and Stock

Location: \_\_\_\_\_

7/63/23

7/63/23

521

(4)

7.0

QC21

FINAL INSPECTION/W/O RELEASE



(4)

Comment: FINAL INSPECTION/W/O RELEASE

7/63/26

Job Completion



U of 03.26

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

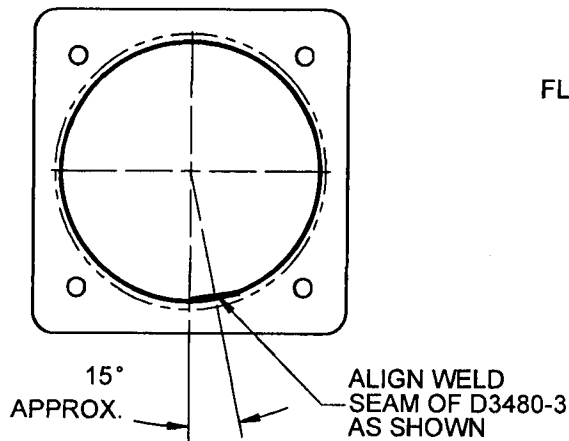
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

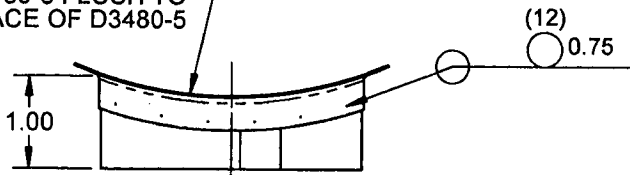
**NOTE:** Date & initial all entries

**DART**

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CHECKED <i>PH</i>	APPROVED <i>H</i>	DRAWING NO. D3480	REV. B SHEET 1 OF 6
DATE 06.08.29		TITLE EYEBALL ADAPTER	SCALE 1:2
A	06.02.06	NEW ISSUE	
B	06.08.29	D3480-3 0.50 was 0.40/D3480-3F 8.930 was 9.330	



SPOT WELD PARTS, THEN  
CUT D3480-3 FLUSH TO  
SURFACE OF D3480-5



### D3480-041 EYEBALL INLET ADAPTER

#### NOTES:

- 1) SPOT WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) IDENTIFY WITH DART P/N D3480-041 USING FINE POINT PERMANENT INK MARKER
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

QTY -041	P/N	DESCRIPTION
X	D3480-041	EYEBALL INLET ADAPTER
1	D3480-3	TUBE
1	D3480-5	FLANGE

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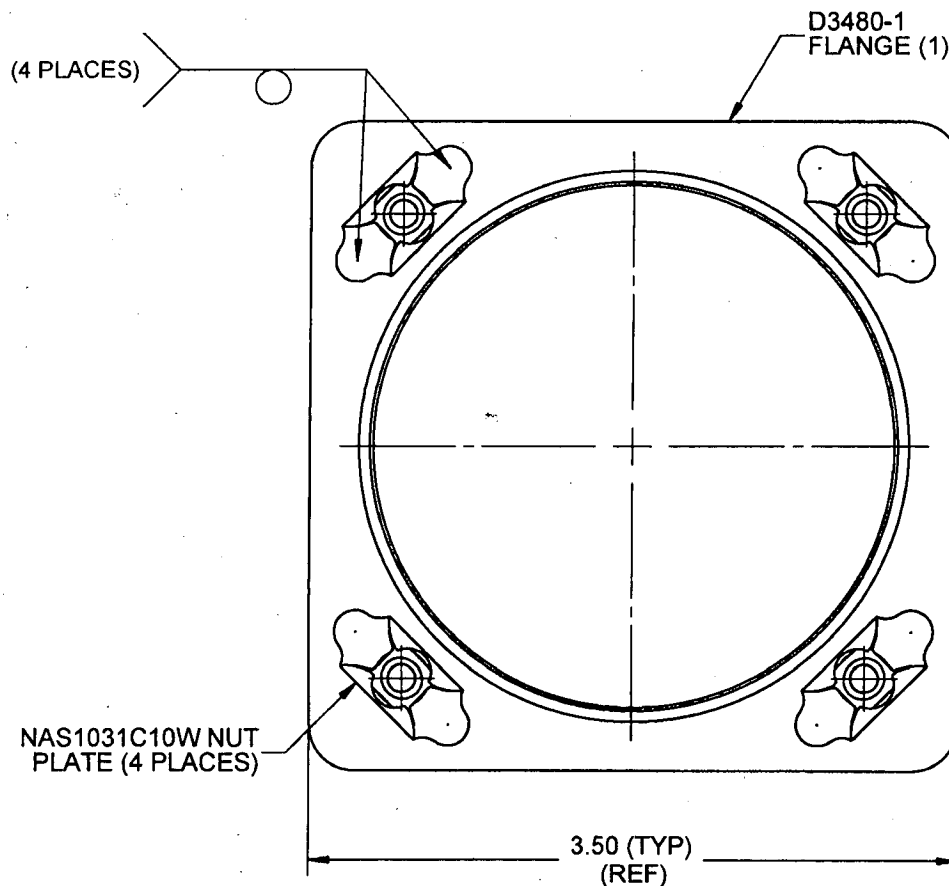
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DATE <b>06.08.29</b>		TITLE <b>EYEBALL ADAPTER</b>	SCALE 1:1

**RELEASED**06.09.19 *PH***D3480-043 EYEBALL ADAPTER****NOTES:**

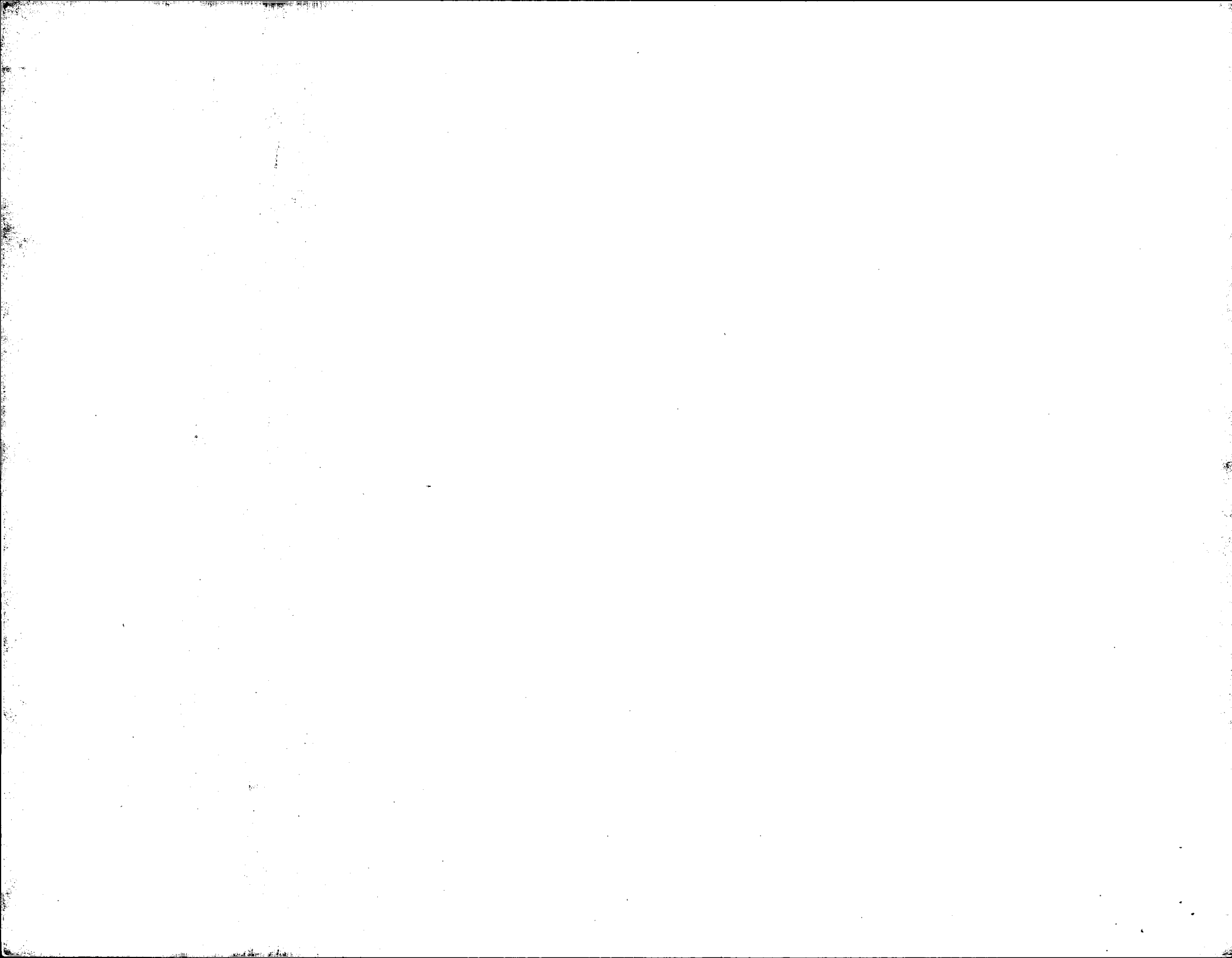
- 1) SPOT WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) IDENTIFY WITH DART P/N D3480-043 USING FINE POINT PERMANENT INK MARKER
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

QTY -043	P/N	DESCRIPTION
X	D3480-043	EYEBALL ADAPTER
1	D3480-1	FLANGE
4	NAS1031C3W	NUTPLATE

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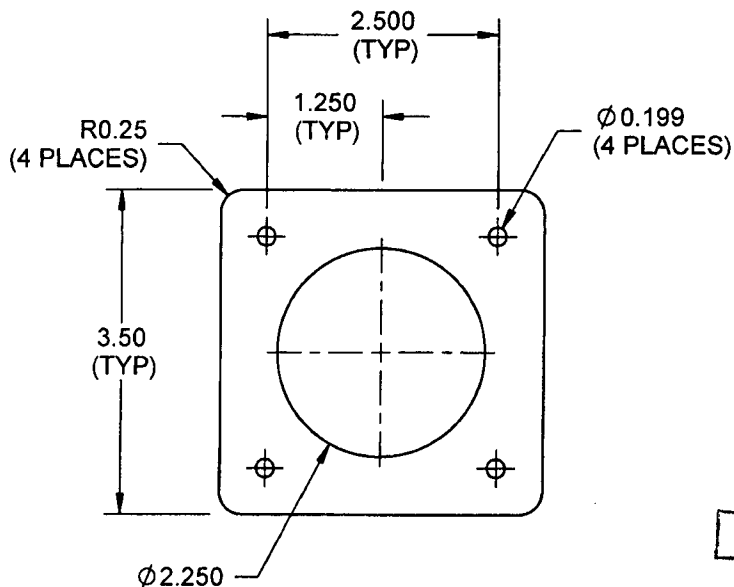
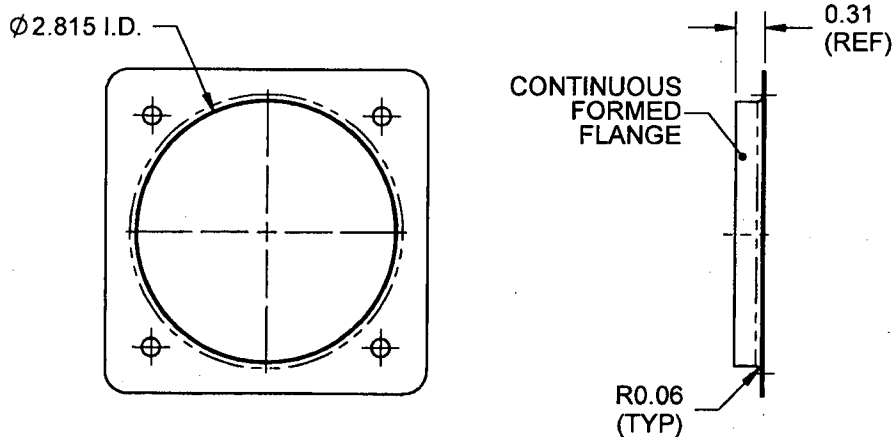
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DATE 06.08.29		TITLE EYEBALL ADAPTER	SCALE 1:2

**RELEASED**06.09.19 *[Signature]***D3480-1F FLAT PATTERN****D3480-1 FLANGE**  
**(MAKE FROM D3480-1F)****NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH  
26 GAUGE SS (0.018 THICK)  
(REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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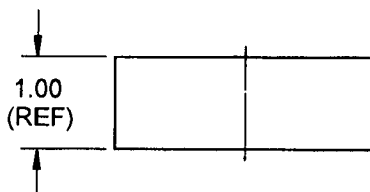
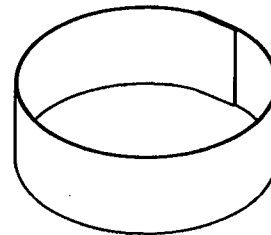
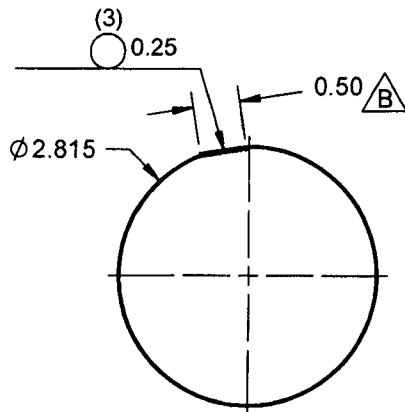
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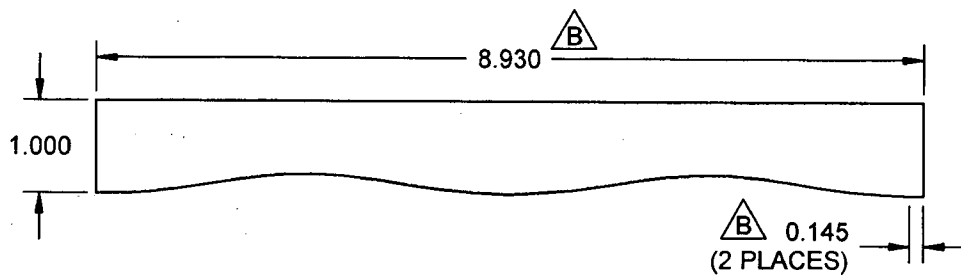


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DATE 06.08.29		TITLE EYEBALL ADAPTER	SCALE 1:2



**D3480-3 TUBE**

RELEASED  
*06.09.19*



**D3480-3F TUBE FLAT PATTERN**

**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH  
26 GAUGE SS (0.018 THICK)  
(REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

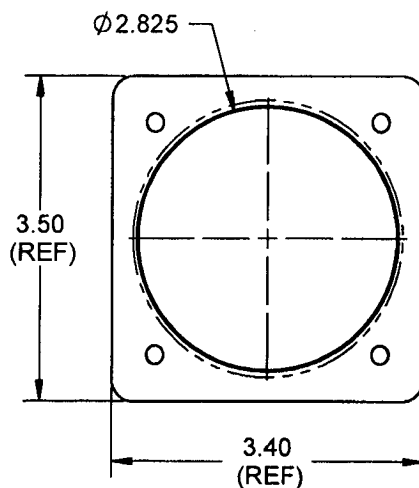
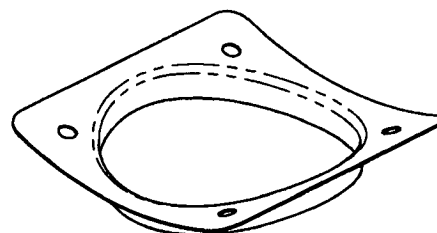
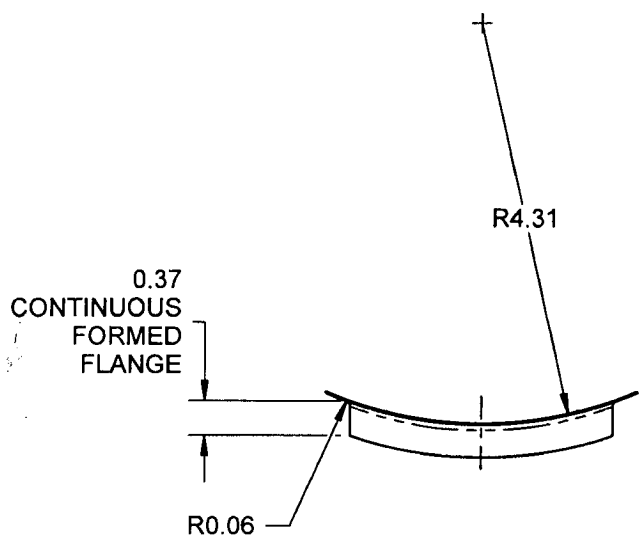
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CHECKED <i>PH</i>	APPROVED <i>H</i>	DRAWING NO. D3480	REV. B
DATE 06.08.29		TITLE EYEBALL ADAPTER	SHEET 5 OF 6 SCALE 1:2



RELEASED  
06.09.19 *H*

### D3480-5 EYEBALL ADAPTER FLANGE

#### NOTES:

- 1) MATERIAL: MAKE FROM D3480-1F
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

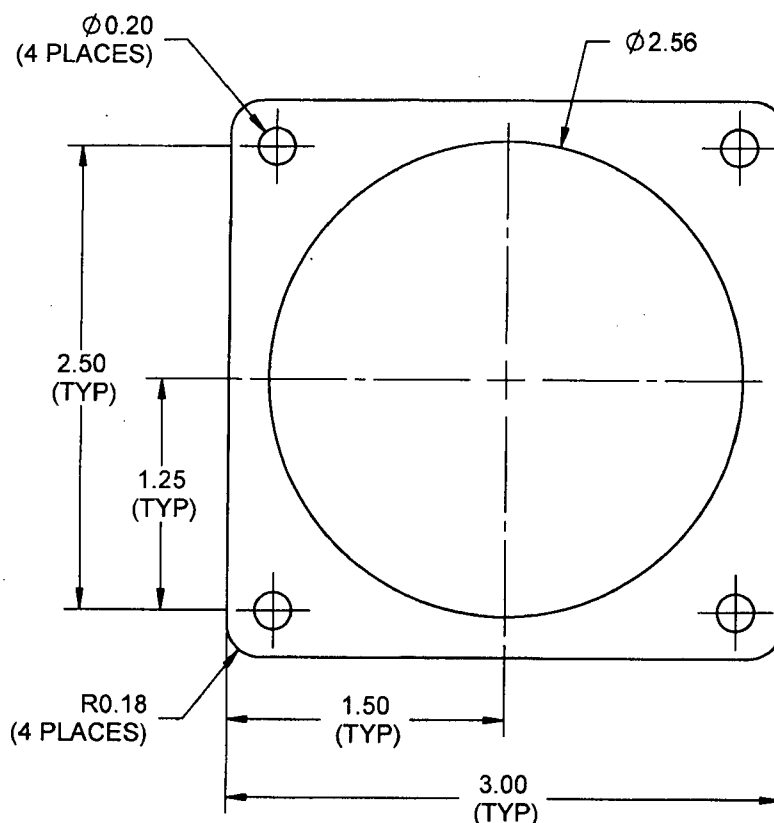
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DATE <b>06.08.29</b>		TITLE <b>EYEBALL ADAPTER</b>	SCALE 1:1

**RELEASED**06-09-19 *[Signature]***D3480-7 GASKET****NOTES:**

- 1) MATERIAL: RED (OR GRAY) 60 DUROMETER HI-TEMPERATURE SILICONE SHEET, 0.125" THICK (REF. DART SPEC. M-SIL60-.125)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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# SPOT WELD TEST RECORD

AMS-W-6858A

CLASS 'C'

TEST NO: 2

EMPLOYEE: Melanie Fauten

PART NUMBER: D3180-043

JOB NUMBER: B 31260

MATERIAL TYPE: 304/316 SS

MATERIAL THICKNESS: 24G

GROUP SPECIFICATION: SS

Group 1: Aluminum & magnesium

Group 2: Iron; nickel; cobalt

Group 3: Titanium

## TEST RESULTS

PASS FAIL

VISUAL: [ / ] [ ]

PENETRATION: [ / ] [ ]

PULL STRENGTH: [ / ] [ ] PSI Reading: \_\_\_\_\_

The individual named above has been trained and is qualified in accordance with standard AMS-W-6858A, and QSI 004 ( ref: 4.3 )

DATE OF TEST COUPON: 07/03/12

QUALIFIER: SB